

## Work Order ID 56512

February 25, 2010 1:03:12 PM



Page 1

Item ID: D4007-3

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 2/25/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *H*

Date: 10-2-25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	Rev. A <i>A</i>
D4007	A-PRELIM	

100	Issue to Job	0.00	PO 11416	(4) Bl 10-2-25
-----	--------------	------	----------	----------------

Waterjet	Memo	0.00		
----------	------	------	--	--

FLOW CNC Waterjet	1-Cut as per Dwg	0.00		
-------------------	------------------	------	--	--

	Dwg Rev:	0.00		
--	----------	------	--	--

	Prog Rev:	0.00		
--	-----------	------	--	--

	2-Deburr if necessary	0.00		
--	-----------------------	------	--	--

110	QC2- Inspect parts off machine FAI/FAIB	0.00		
-----	---	------	--	--

QC	Memo	0.00		
----	------	------	--	--

Quality Control	0.00			
-----------------	------	--	--	--

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*RGS/19/04*

*Receive & inspect for forward change  
Ensure Collected*

*PRELIMINARY ISSUE*

*PO 11416 (4) Bl 10-2-25*

**Work Order ID 56512**

Page 2

February 25, 2010 1:03:12 PM

Item ID: D4007-3

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Setup Start



Revision ID:

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Start Date: 2/25/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp~~QC8-Inspect parts second check~~

0.00

QC6 inspect parts &amp; mat. carb.

0.00

**QC APPROVAL**

Memo

8wks/23 to pole day only

(qc)

130



Brake NC

Brake NC

Bend as per dwg

0.00

Memo

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00



# Picklist Print

Page 1

February 25, 2010 1:03:17 PM

Work Order ID: 56512



Parent Item: D4007-3



Parent Item Name: Support

Start Date: 2/25/10

Required Date: 3/17/10

Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD

Start Qty: 4.00

Required Qty: 4.00

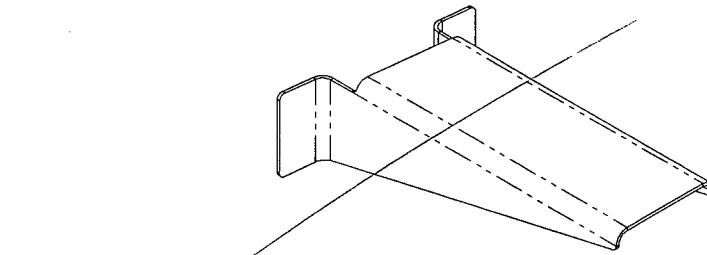
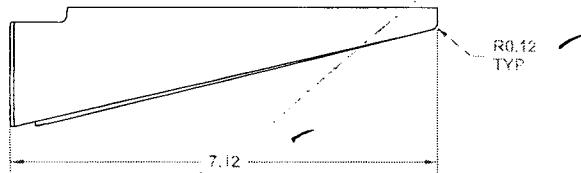
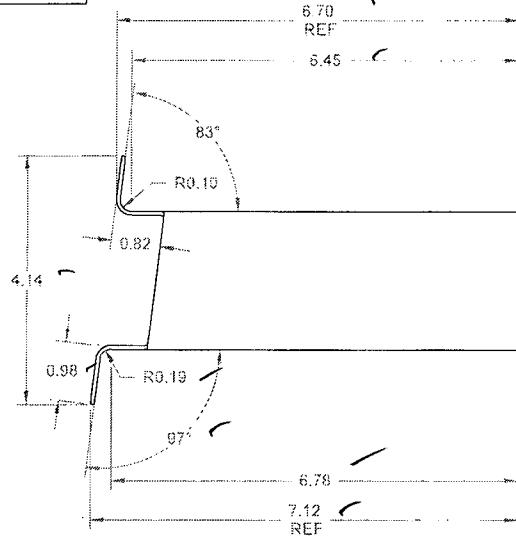
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	146.1602	1.3263			

2024-T3S.063 sheet

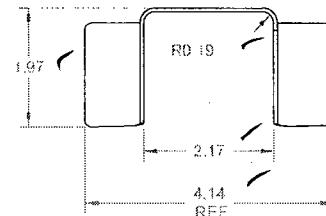
D4007-3P-56512

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	146.1601505	
105916	1.09	
110980	5.4854	
111787	12.2847505	
113866	69.3	
113867	56	
19059	2	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-3	JCA-M47-2-18



# PRELIMINARY ISSUE



56512

D4007-3 TOP SUPPORT BRACKET

A

NOTES:

- 1) MATERIAL: MADE FROM D4007-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.19 lbs

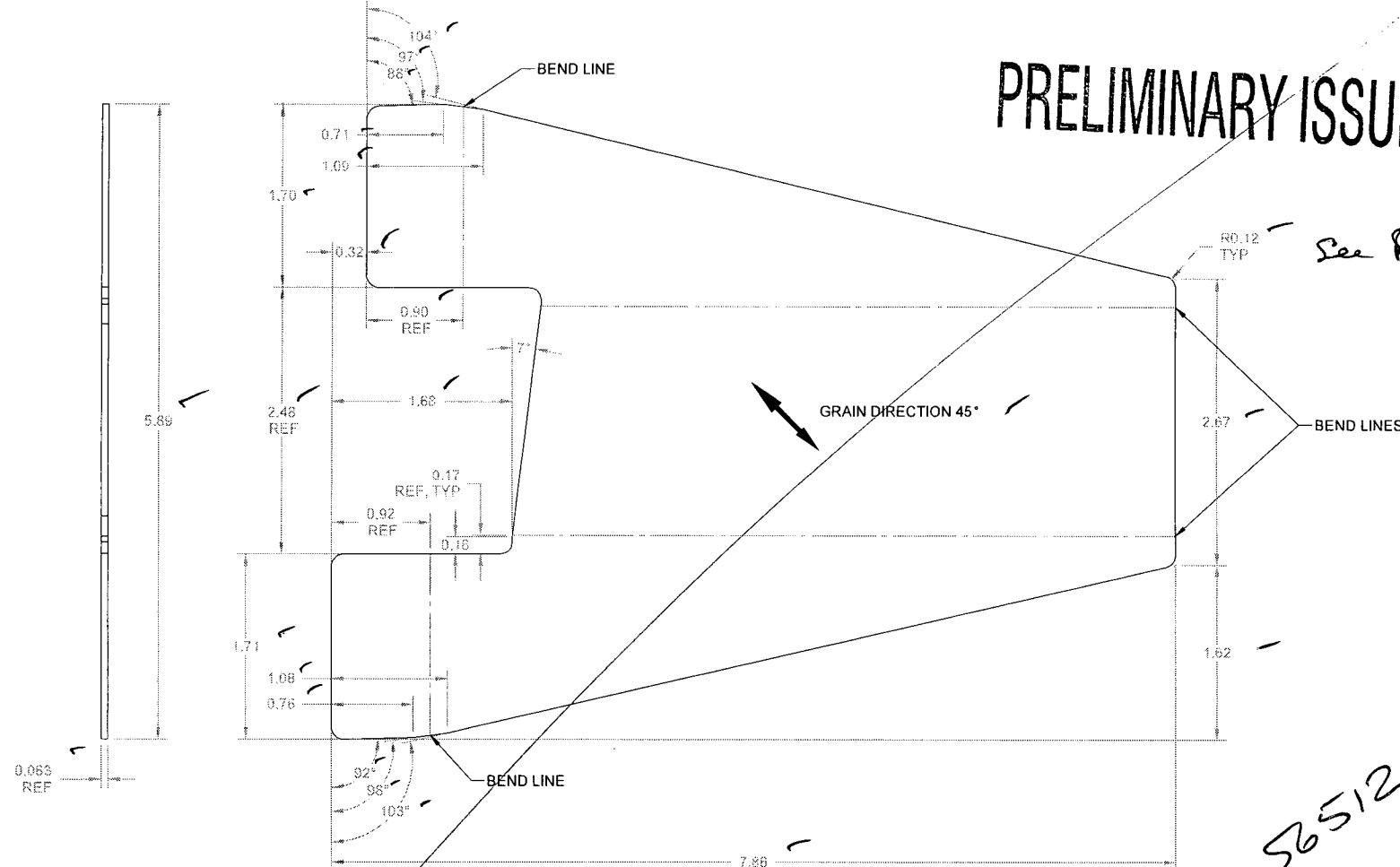
DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>EZ</i>	DRAWING NO.
MFG. APPR.	<i>EZ</i>	D4007
APPROVED	<i>AB</i>	REV. A
DE APPR.	<i>AB</i>	SHEET 3 OF 5
TITLE		SCALE
SUPPORT		NTS
DATE		10.02.05

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# PRELIMINARY ISSUE

See Rev. A

56512



**D4007-3F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

DESIGN	12	DART AEROSPACE LTD
DRAWN	BB	HAWKESBURY, ONTARIO, CANADA
CHECKED	B	DRAWING NO.
MFG. APPR.	E	D4007
APPROVED	IP	SCALE
DE APPR.		TITLE
DATE	10.02.05	SUPPORT
NTS		

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO11416

Purchase Order Date 2/24/10

PO Print Date 2/24/10

Page Number 1 of 1

Order From : VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	

Ship To : DART AEROSPACE LTD      1270 ABERDEEN  
    HAWKESBURY, ON K6A 1K7  
    CANADA

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4005-3P	Fwd Restaint Beam	2/25/10 3/12 Yes	4.00 Each	Purolator ground	\$99.0000	\$396.00

Special Inst: As per DWG:D4005 Rev: PA1  
B# 55835

2	D4007-1P	Support	2/25/10 3/12 Yes	4.00 Each	Purolator ground	\$80.0000	\$320.00
---	----------	---------	---------------------	--------------	------------------	-----------	----------

Special Inst: As per DWG: D4007 Rev: PA1  
B#56460

PO Total: \$716.00

PO Instructions: GFI QUOTE# GFI 2087

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required when applicable

Change Nbr: 1

Change Date: 2/24/10



Est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

180 AVENUE LABROSSE  
POINT-CLAIRE, QC, CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849



## BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
JR - DY	MO - MO	AN - YR		
16	03	10	0434430	1/1



ENDU À / SOLD TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA
DART	GFI-0299	0211141	PO11416
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.	DESCRIPTION	
4	D4007-3P	SUPPORT CERTIFICATE OF CONFORMANCE REQ.	
MFG. JOB# <u>0211141-001</u> QTY <u>4</u>			
		EXPÉDITEUR SHIPPER	N° DE BON DE LIVRAISON SHIPPING MEMO NO.

# CERTIFICATE OF COMPLIANCE

## CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

8/16/23

CERTIFICATE NO.	1	OUR JOB NO	J0211141	SHIPPING MEMO	0434430	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	4 PCS	PO11416	D4007-3P		SUPPORT	PA1
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
AL 2024-T3		SAMUEL / KAISER ALUMINUM		419327A2		
1	PROCESS			PROCESSOR	RELEASE NOTE #	
1	FIRST ARTICLE INSPECTION REPORT ON FILE			GFI	CONFORMS	
2	REF. GFI MANUFACTURING JOB NUMBER J0211141-001 (4 PCS)					
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 17 MARCH 2010

G.F.I. Q.C. REP.

B. Samee





LES METAUX SPECIALISES SAMUEL  
21525 CLARK-GRAHAM  
BAIE D'URFE, QUEBEC, CANADA  
H9X 3T5

No 001468863

TRANSPORTEUR/CARRIER NAME  
CASTERO TRANSPORT

(514) 457-3399 FAX (514) 457-9393

CAMIONTRUCK NOM DE LA BRANCHE/SALES BRANCH NAME  
099 LES METAUX SPECIALISES SAMUEL

DATED/EXPIREDATE OF SHIPMENT  
9/14/09

PAGE 1 DE/OF 1

VENDU À/SOLD TO:  
GFI DIVISION OF THOMAS & BETTS, LIMITED  
180 AVENUE LABROSSE  
POINTE CLAIRE  
POINTE-CLAIRES  
QC  
H9R1A1 (514) 630-4877

EXPÉDIÉ À/SHIP TO: TAB: DEST

G.F.I. INC  
180 AVENUE LABROSSE  
POINTE-CLAIRES  
QC  
H9R1A1 CA (210678-00001)

N° COMMANDE N° ITEM	DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT				
	#Comm du client:	0075894		Cert/Test:	TRUCK
489556-01	1 PCS FEUILLES ALUMINIUM .0630"x48"x144" QQA250/4 BARE	2024 T3		43 LVR	
Description	Art	Pd ca	Qté	#Étiq	Vendeur
#Étiq mln	#À soul	1	48.000	Etq princ	#Coul
1297052		1	48.000	4564255	017
Total:		1	48.000	D851930	419327A2

Poids total:

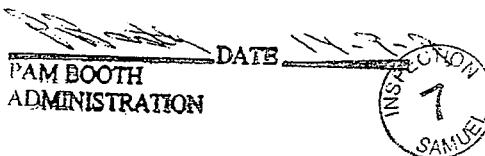
#Total paquets:

43 LVR

Commentaires connaissance:

#### CERTIFICAT DE CONFORMITÉ

LE MATERIEL DETAILLE CI-DESSUS EST CERTIFIÉ  
CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX  
SPECIFICATIONS DES NORMES DU GRADE. SVP VOUS  
RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:



NIR: R-539477-1

PRÉPAYÉ PAR CHARGES	PORT PAYÉ/PREPARED EXPEDITEUR/DISPATCHER	PORT DU COLLECT INST. VOITURIER/DRIVER INSTRUCTIONS	VALORIS (\$2.00/lb max moins d'avis contraire; VALORISATION (Max \$2.00/lb unless otherwise stated) VALORISATION DE L'EXPEDITION VALORISATION DE L'EXPEDITION
		VOITURIER/DRIVER	REÇU PAR/RECEIVED BY

SHIP TO:	SAMUEL BAIE D'URFE 21525 CLARK-GRAHAM BAIE D'URFE, PQ, CA H9X3T5	
SOLD TO:	SAMUEL LAVAL 2225 FRANCIS HUGHES LAVAL, PQ, CA H7S1N5	

# KAISER

## ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

### CERTIFIED TEST REPORT

Serial Number  
4146676

CUSTOMER PO NUMBER:		WORK PACKAGE:		CUSTOMER PART NUMBER:		SHIP RUN/LOAD ID:	GOVT CONTRACT NUMBER:
N21479						101411/2	
KAISER ORDER NO:	LINE ITEM:	SHIP DATE:	ALLOY:	CLAD:	TEMPER:	PRODUCT DESCRIPTION:	
1074833	3	11-NOV-2008	2024	BARE	T3	MILL FINISH SHEET	
WEIGHT SHIPPED:	QUANTITY:	B/L NUMBER:	GUAGE:		WIDTH:	LENGTH:	
3180 LB	71 PCS EST.	2020211	0.0630 IN		48.000 IN	144.000 IN	

### Certified Specifications

AMS 4037/RevN  
CMMMP 019/RevD

AMS-QQ-A-250/4/RevA  
CMMMP 025/RevR

ASTM B 209/Rev07

Test Code: 1504

### Test Results

Lot: 419327A2 Cast 443

Drop 13

Ingot 3

S. [Signature] 123

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	67.4 : 67.6 (465 : 466)	45.0 : 45.1 (310 : 311)	17.1 : 19.0

(ASTM E1251)

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	
Actual	0.09	0.25	4.4	0.58	1.3	0.01	0.12	0.02	0.01	0.01	TOT	0.03

### ALLOY LIMITS

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.8	0.30	1.2	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

### TEST NOTES

2024-T351 plate 3.001-4.000" thick, if ultrasonically inspected, meets requirements of CMMPO25 per SDR CMMPO25-KaiserT-2.



Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4146676

### CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

A handwritten signature in black ink that reads "Bill Poynor".

Page 2 of 2

8

7

6

5

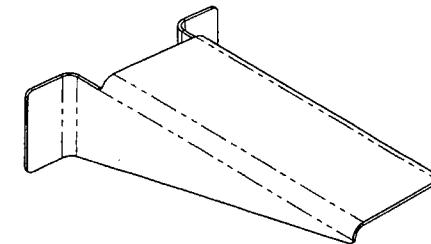
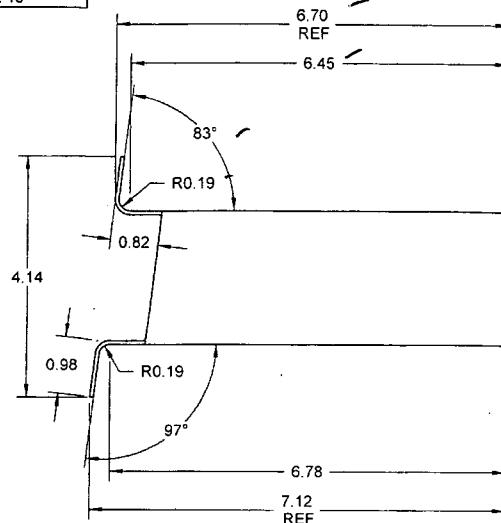
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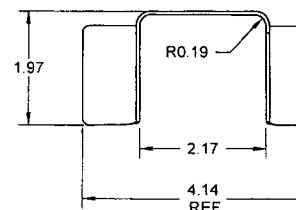
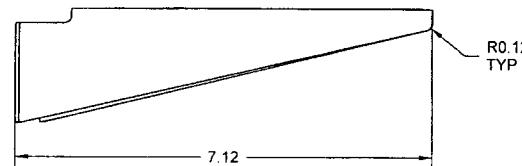
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1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-3	JCA-M47-2-18



w/p 56512



D4007-3 TOP SUPPORT BRACKET

A  
NOTES:

- 1) MATERIAL: MADE FROM D4007-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.19 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	DRAWING NO. REV. A
MFG. APPR.	<i>AS</i>	D4007 SHEET 3 OF 5
APPROVED	<i>AS</i>	TITLE SCALE
DE APPR.	<i>AS</i>	SUPPORT NTS
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8

7

6

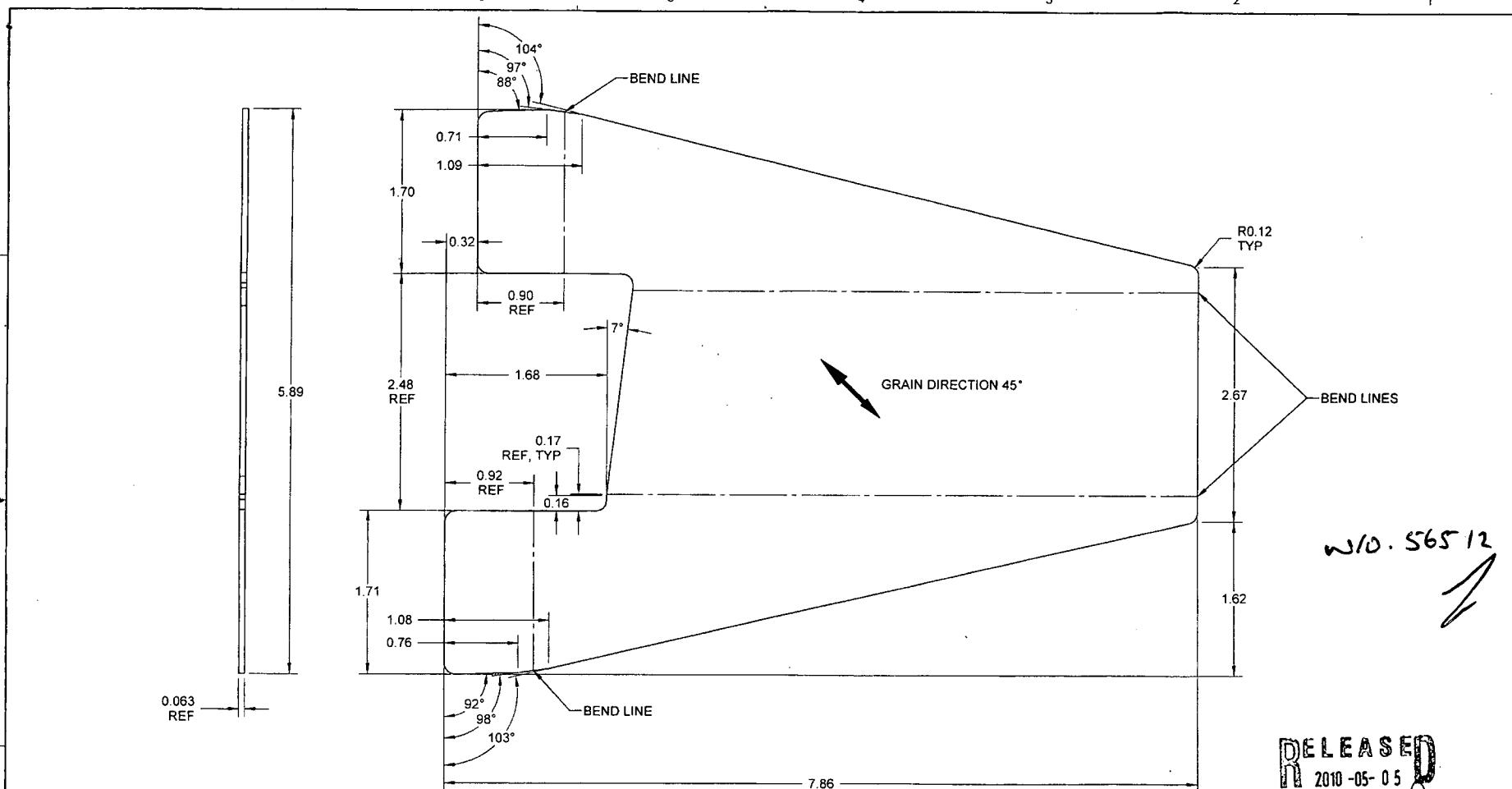
5

4

3

2

1



D4007-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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- 7) WEIGHT: 0.19 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO. REV. A	
MFG APPR.	<i>PE</i>	D4007 SHEET 4 OF 5	
APPROVED	<i>MP</i>	TITLE SCALE	
DE APPR.	<i>AS</i>	SUPPORT NTS	
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RELEASED  
2010-05-05